



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

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RB6872882-9B
Job Sheet 197193



Part No: RB6872882-9B

Job Qty: 3 pcs

Part Name: Handle Hub



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/2/19

Job Tracking No:

Due Date: 7/30/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RB6872882 Rev. G IPP Rev. A 18.09.17 New issue DP Verify DD/IPP Rev. B 19.06.28 Drawing Revision DP Verify

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Conventional Lathe - 1	3 pcs	7/30/19	7/30/19	0.00	1.50	Conventional Lathe - 1		
							Conventional Lathe - 2		
110	QC 2	3 pcs	7/30/19	7/30/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		



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Container No: S200311



Part: RB6872882-9B

Job No: 197193

Serial No/Batch: S200311

Revision: G

Inspector:

Exp Date:

Instructions:

Date: 07/24/19

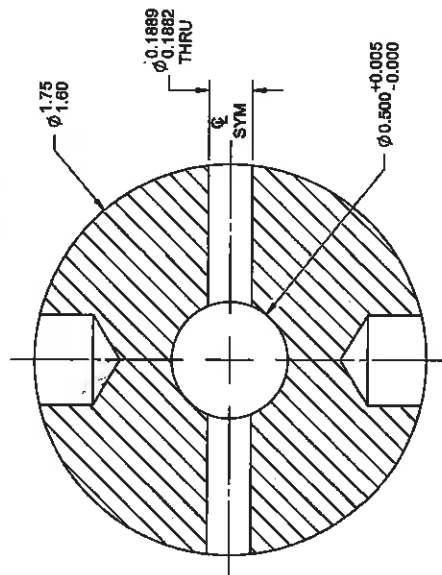
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				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
120	Conventional Mill - 1 - B4B	3 pcs	7/30/19	0.00 1.00	Conventional Mill - 1 - B4B
					Conventional Mill - 2 - B4B
130	QC 2	3 pcs	7/30/19	0.00 0.00	QC 2 - 1
					QC 2 - 12
					QC 2 - 14
					QC 2 - 17
					QC 2 - 19
					QC 2 - 2
					QC 2 - 20
					QC 2 - 22
					QC 2 - 23
					QC 2 - 25
					QC 2 - 32
					QC 2 - 33
					QC 2 - 35
					QC 2 - 39
					QC 2 - 4
					QC 2 - 40
					QC 2 - 44
					QC 2 - 45
					QC 2 - 48
					QC 2 - 49
					QC 2 - 50
					QC 2 - 51
					QC 2 - 52
					QC 2 - 57
					QC 2 - 62
					QC 2 - 63
					QC 2 - 8
					QC 2 - 66
					QC 2 - 64
					QC 2 - 65
					QC 2 - 5
					QC 2 - 71
					QC 2 - 73
					QC 2 - 69
140	QC 8	3 pcs	7/30/19	0.00 0.00	QC 8 - 12
					QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9

				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
150	Packaging 3-1 - Stock - B4B 3 pcs	7/30/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	62
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
160	QC 21 - SA	3 pcs	7/30/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53
Part Op 100 - Manufacture as per dwg - 1-Machine as per DWG. 2-Deburr Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB 120 - 1-Machine as per DWG. 2-Deburr 130 - QC2- Inspect parts off machine FAI/FAIB 140 - QC8- Inspect parts - second check 150 - Identify as per dwg & Stock Location 160 - QC21- Final Inspection - Work Order Release					DAS 21 9-89 JUL 2 9 2019
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
MT-4140QT-R1.750	AISI 4140 Quenched & Tempered Steel Round Bar 1.750" Dia.	.1548 ft (.0516 ea)	100-Conventional Lathe - 1	5048045	

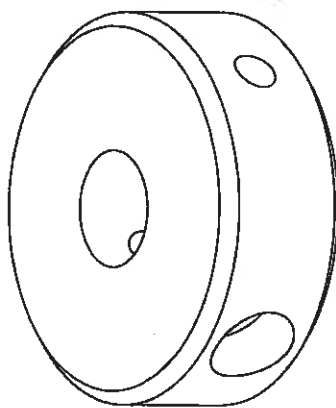
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Conventional Lathe - 1	MT-4140QT-R1.750	0	4	0
Part Specifications				
Specifications could not be found.				

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SECTION P-P
RB6872882-9B HANDLE HUB

SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 197153



DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. G SHEET 11 OF 11	
TOOL PART # RB68728B2		TITLE TURBINE FRONT BEARING PULLER NTS	
DATE 2019-06-27		SCALE 	
DESIGN	VLM		
DRAWN	VLM		
CHECKED	KPT		
MFG. APPR.	JRD		
APPROVED			

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NOTES:

- 1) MATERIAL: 4140 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- .1"
X.XX = +/- 0.01" / +/- .0.5"
X.XXX = +/- 0.005" / +/- .0.1"
X.XXXX = +/- 0.0008" / +/- 0.05"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION Rework ☐ ☐ ☐ Scrap ☐ ☐ ☐ Use-as-is ☐ ☐ ☐				DEPARTMENT/PROCESS Skid-tube ☐ ☐ ☐ ☐ ☐ Machining ☐ ☐ ☐ ☐ ☐ Large Fab ☐ ☐ ☐ ☐ ☐ Cross tube ☐ ☐ ☐ ☐ ☐ Small Fab ☐ ☐ ☐ ☐ ☐ Finishing ☐ ☐ ☐ ☐ ☐ Eng. (Non-AW) ☐ ☐ ☐ ☐ ☐ Prod. Eng. Coord. ☐ ☐ ☐ ☐ ☐ Rec/Store/Packaging ☐ ☐ ☐ ☐ ☐ Engineering ☐ ☐ ☐ ☐ ☐ Water Jet ☐ ☐ ☐ ☐ ☐ Supplier ☐ ☐ ☐ ☐ ☐ Quality ☐ ☐ ☐ ☐ ☐				Date: _____ Sequence #: _____ QTY Affected: _____		MRB (QS1042) _____									
Description Work Order Deviation						Disposition															
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐						FAULT CATEGORY															
						Pressure/Forced Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐				Contamination Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐				Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐				Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐			
						Other/Details: _____															
Completed By _____						Lead hand / Supervisor _____						QC / QA Coordinator _____									